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007157

D350-591-133
Job Sheet 186312



Part No: D350-591-133

Job Qty: 4 ea

Part Name: AFT Maintenance Step, Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/14/18

Job Tracking No:

Due Date: 11/28/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG DSI9712 REV A , IIN-D350-591 REV H , D2946 REV.C IPP Rev:B 05.10.14 Modified step 10 KJ/EC IPP Rev:C

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		11/28/18	0.00	0.00	Start Up Large Fab-4		CPC
110	Large Fab	4 pcs		11/28/18	0.00	2.78	Large Fab 8		MA
120	QC	4 pcs		11/28/18	0.00	0.00	QC6		CPI
130	Large Fab	4 pcs		11/28/18	0.00	2.78	Large Fab 2		CPC
140	QC	4 pcs		11/28/18	0.00	0.00	QC9		
150	QC	4 pcs		11/28/18	0.00	0.00	QC5		
160	HandFinish	4 pcs		11/28/18	0.00	0.61	HandFinish1		D.R. 18/12/18
170	QC	4 pcs		11/28/18	0.00	0.00	QC7-2		38
180	Large Fab	4 pcs		11/28/18	0.00	2.78	Large Fab 2		SLU 9-89
190	QC	4 pcs		11/28/18	0.00	0.00	QC10		CPC
200	QC	4 pcs		11/28/18	0.00	0.00	QC5		CPC
210	HandFinish	4 pcs		11/28/18	0.00	0.61	HandFinish1		D.R. 18/12/18
220	Powdercoat	4 pcs		11/28/18	0.00	0.41	Powdercoat1		BR 18-12-17
230	HandFinish	4 pcs		11/28/18	0.00	0.61	HandFinish3		BER 18-12-19
240	QC	4 pcs		11/28/18	0.00	0.00	QC3		DEC 27 2018
250	Packaging	4 pcs		11/28/18	0.00	0.00	Packaging1-3		DEC 27 2018
260	QC	4 pcs		11/28/18	0.00	0.00	QC4		DEC 27 2018
270	Packaging	4 pcs		11/28/18	0.00	0.00	Packaging3-1		DEC 27 2018
275	DC	4 pcs		11/28/18	0.00	0.00	DC		DEC 27 2018
280	QC21-FG	4 Ea		11/28/18	0.00	0.00	QC21		DEC 27 2018

Part Op 110 - 1-Cut D2622-120 extrusion to 62.06" long as per Dwg D2946

Descriptions: 130 - 1-Deburr and Bevel ends for welding Use DT8440 jig

180 - Remove alodine prior to welding. Weld end cap as per Dwg D2946. Grind end cap weld flush.

220 - START TIME: 11:30 O.V.T. 3:00 FINISH 12:00 10

270 - Identify and pack for shipping as per PPPD350-591-133 Location:FG038

275 - Photocopy bluefile and type labels as per PPP D350-591-133 CHG004

Wing walk M138963

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	4 Ea (1 ea)	90-Start up Operation	S 104 007
D2734	Step End Plate	8 Ea (2 ea)	130-Large Fab	5102 822
D2944	Step Mounting Plate	8 Ea (2 ea)	130-Large Fab	50606 50

006578

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																									
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MS20601-AD4W2	Rivet	4 Ea (1 ea)	180-Large Fab	5083539
AN4-11A	Bolt	16 Ea (4 ea)	250-Packaging	5117002
AN4-16A	Bolt	32 Ea (8 ea)	250-Packaging	5112905
AN4-7A	Bolt	8 Ea (2 ea)	250-Packaging	5087520
D2230-1	Mounting Lug	16 Ea (4 ea)	250-Packaging	5129816
D2230-3	Mounting Lug	16 Ea (4 ea)	250-Packaging	5132811
D2732-030	Rubber Cushion - 3"	16 Ea (4 ea)	250-Packaging	5127242
D2945	Mounting Plate	4 Ea (1 ea)	250-Packaging	5078919
D3338-1	Mounting Lug	4 Ea (1 ea)	250-Packaging	5109230
MS21042L4	Nut	56 Ea (14 ea)	250-Packaging	5112434
NAS1149D0463J	Washer	56 Ea (14 ea)	250-Packaging	5092780

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	4	98	0
130-Large Fab	D2734	8	34	0
	D2944	8	34	0
180-Large Fab	MS20601-AD4W2	4	97	0
250-Packaging	AN4-11A	16	82	0
	AN4-16A	32	472	0
	AN4-7A	8	188	0
	D2230-1	16	17	0
	D2230-3	16	53	0
	D2732-030	16	192	0
	D2945	4	32	0
	D3338-1	4	35	0
	MS21042L4	56	1,976	0
	NAS1149D0463J	56	2,807	0

Part Specifications

Specifications could not be found.

Plex 11/14/18 8:50 AM Dart.lajeunesse.marie



DART
AEROSPACE

Container No: S129748



Part: D350-591-133

Job No: 186312

Serial No/Batch: S129748

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 1d at FAA, STC SH967NE 04/12/21, BRAZIL 1

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Email: sales@dartaero.com
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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